

Date: Thursday, 3/8/2007 12:37:09 PM
User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: LID PRO ARM ASSEMBLY (SHORT)
Job Number	: 31105		
Estimate Number	: 10258		
P.O. Number	: N/A	Part Number	: D2332041
This Issue	: 3/8/2007	S.O. No.	: N/A
Prsht Rev.	: NC	Drawing Number	: D2332 REV C1
First Issue	: N/A	Project Number	: N/A
Previous Run	: 30547	Drawing Revision	: C1
Written By	:	Material	: N/A
Checked & Approved By	:	Due Date	: 4/5/2007
Comment	: Est: B 02/08.12 Re-format; Incorporated D2332-13/11-7/5 K J/RF	Qty:	20
Additional Product		Unit:	Each
Job Number:			
Seq. #:	Machine Or Operation:	Description :	
1.0	M304TR1000W049	304 RD Tube 1.0" x .049W	
Comment:	Qty.: 0.4368 f(s)/Unit Total : 8.7360 f(s) Material: 1.000" OD x 0.049" wall SS Tube (Seamless) <u>M103240</u>	Batch	<u>mf. 07-04-25</u>
2.0	M304R250	1/4" 304 SS Roundbar	
Comment:	Qty.: 0.1092 f(s)/Unit Total : 2.1840 f(s) Material: Ø0.250" 304SS Rod Batch <u>M107931</u>	Batch	<u>mf. 07-04-25</u>
3.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1	
Comment:	SMALL & MEDIUM FAB RESOURCE 1		
1-Cut to length as per Dwg D2332 (D2332-7) Locking Collar		<u>dm 07/04/19</u>	<u>20</u>
2-Cut to length as per Dwg D2332 (D2332-5) Stop Pin		<u>dm 07/03/30</u>	<u>20</u>
3-Deburr			
4.0	M304TR0500W035	304 RD Tube .500 x .035W	
Comment:	Qty.: 1.2080 f(s)/Unit Total : 24.1600 f(s) 304 RD Tube .500 x .035W	<u>M102742</u> <u>M103453</u>	<u>(20) 20</u> <u>20 - SB 07/03/20</u>

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Job Number:		
Seq. #:	Machine Or Operation:	Description :
5.0	BRAKE NC	NC BRAKE
Comment: NC BRAKE		
Punch or form to length as per Dwg D2332 (D2332-11) using DT8012 (Note: Make (2) D2332-11 Prop Arms per assembly.)		SB 07/03/20 20
6.0	LARGE FAB 1	LARGE FABRICATION RESOURCE 1
Comment: LARGE FABRICATION RESOURCE 1		FM 07/04/25 20
1-Drill hole in D2332-11 as per Dwg D2332 using Drill Jig DT8459. Deburr. (Drill 1 per assembly)		
2-Weld D2332-11 and D2332-5 as per Dwg D2332 using Welding Jig DT8298. (Weld 1 per assembly)		
A/R	SS Rod Batch: M102756	FC 07/04/30 20
7.0	QC9	VISUAL WELDING INSPECTION
Comment: VISUAL WELDING INSPECTION		M 07/04/30 20
8.0	QC5	INSPECT WORK TO CURRENT STEP
Comment: INSPECT WORK TO CURRENT STEP		M 07/04/30 20
9.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
Comment: SMALL & MEDIUM FAB RESOURCE 1		
1-Tumble		
2-Assemble as per Dwg D2332		
10.0	AN44A	Bolt
Comment: Qty.: 1.0000 Each(s)/Unit Total : 20.0000 Each(s) Pick: Qty Part Number Description Batch		M101291- P 07/05/02

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA:  Date: 07/05/03
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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Job Number:		
Seq. #:	Machine Or Operation:	Description :
11.0	AN960JD416L	Washer
Comment: Qty.: 3.0000 Each(s)/Unit Total : 60.0000 Each(s) Pick: Qty Part Number Description Batch 3 AN960JD416L Washer <u>M103962</u>		
12.0	MS21042L4	Nut
Comment: Qty.: 1.0000 Each(s)/Unit Total : 20.0000 Each(s) Pick: Qty Part Number Description Batch 1 MS21042L4 Nut (or -4) <u>M103914</u> - <u>P-7/5/02</u> (20)		
13.0	QC5	INSPECT WORK TO CURRENT STEP
Comment: INSPECT WORK TO CURRENT STEP <u>SB 07/05/02</u> (20)		
14.0	PACKAGING 1	PACKAGING RESOURCE #1
Comment: PACKAGING RESOURCE #1 Identify and Stock Location: <u>SJ210</u> <u>P-7/5/03</u> (20)		
15.0	QC21	FINAL INSPECTION/W/O RELEASE
Comment: FINAL INSPECTION/W/O RELEASE <u>07/05/03</u> (20)		
Job Completion		

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

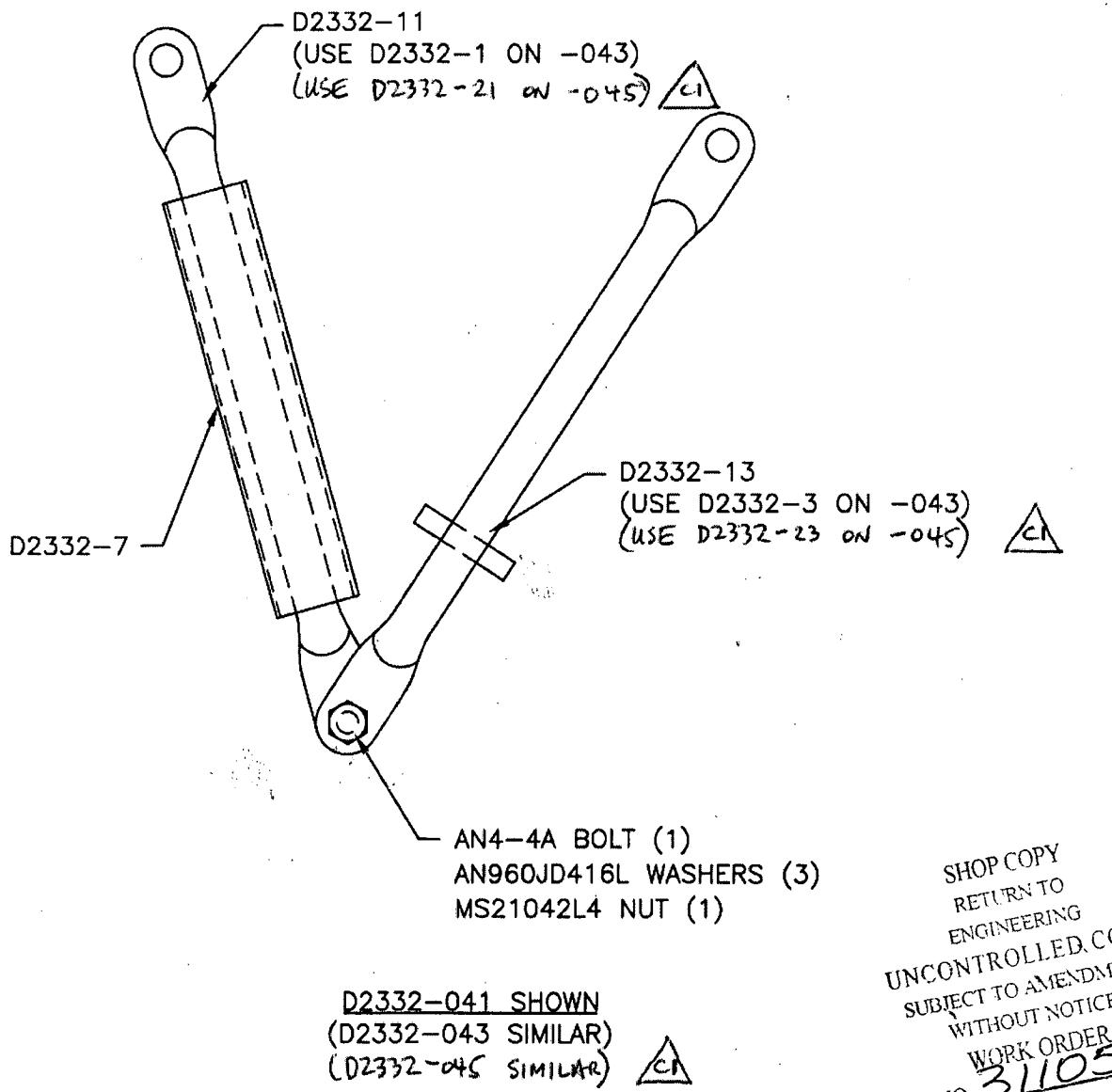
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DARTCOPY ISSUED
CENTRE

DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO.	REV. C
		D2332	SHEET 1 OF 2
DATE	TITLE		SCALE
03.07.03	LOD PROP ASSEMBLY		NTS
A	94.12.16	NEW ISSUE	
B	97.09.30	CHANGE 416 WASHERS TO 416L	
C	03.07.03	MAKE -041 PROP 6.69" LONG (STD) MAKE -043 PROP 8.00" LONG (OPT.)	
C1	03.08.06	ADD -045 PROP (7.25" LONG)	

RELEASED
03.07.04

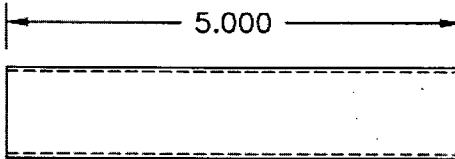
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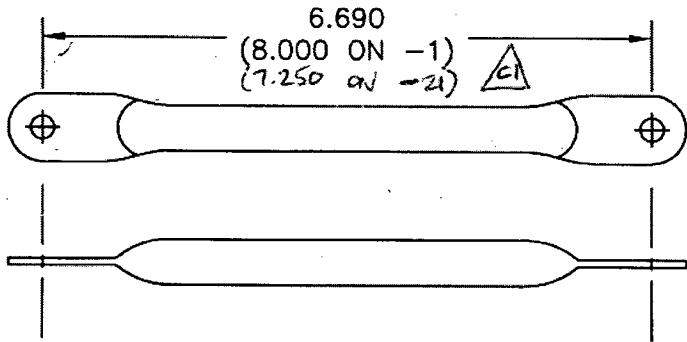
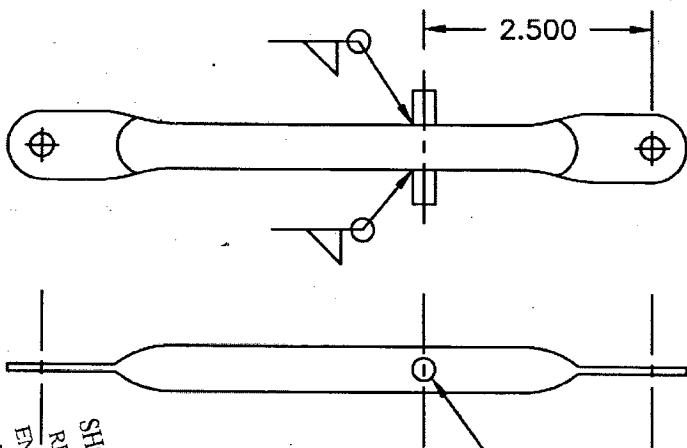
DART

DESIGN # *[Signature]*
 DRAWN BY *[Signature]*
 DRAWING NO. D2332
 SHEET 2 OF 2
 REV. C

DART AEROSPACE LTD
 HAWKESBURY, ONTARIO, CANADA
 WORK ORDER NO. 31105

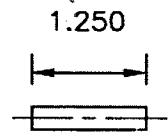
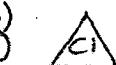


D2332-7 LOCKING COLLAR

D2332-11 PROP
(D2332-1 SIMILAR)

D2332-13

M/F D2332-11 & D2332-5

(D2332-3 SIMILAR - M/F D2332-1 & D2332-5)
(D2332-23 SIMILAR - M/F D2332-21 & D2332-5)

D2332-5 STOP PIN

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 31105

NOTES:

1. MATERIAL: 0.5 OD x 0.035 WALL SS TUBE (D2332-1/-11) M304TR0.500W.035
 0.25 OD SS ROD 1.25 LONG (D2332-5) M303R0.250
 1.0 OD x 0.049 WALL SS TUBE (D2332-7) M304TR1.000W.049
2. TUBE ENDS ARE CENTER-CENTER FOR D2332-1/-3 & D2332-11/-13

RELEASED
03.07.04

